

# Work Order ID 52416

September 23, 2009 1:57:29 PM

Page 1

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:


Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D206-642	Rev M
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100

DC

0.00

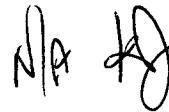
0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-541  
CHG003



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52416

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Page 2

Item ID: D206-642-541

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QC:

Date:

SPC (Y/N):

Date:

## Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	Skidtubes	0.00	0.00							
		<b>Memo</b>									
		1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.									
		2- remove fwd indexing ridge as per dwg D3274. Prepare for welding									
		3- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: <u>M109213</u>									
		4- grind fwd cap weld on top surface only									
		5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.									
		6-Drill Aft cap pilot hole using DT8025									
		7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274.									
		8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #									
		9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.									

DP 9-9-29

— AWM 9-9-29

PD 09.09.30

DP 9-9-30

DP 9-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

September 23, 2009 1:57:34 PM

**Reference:**

Revision ID: M

**Item Name:** Replacement Skidtube

**Start Date:** 9/23/09      **Start Qty:** 1.00

**Cust Item ID:**

**Required Date:** 10/08/09      **Req'd Qty:** 1.00

**Customer ID:**

**Customer Name:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

### Hours

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



September 23, 2009 1:57:40 PM

**Reference:**

Revision ID: M

**Item Name:** Replacement Skidtube

**Start Date:** 9/23/09

**Start Qty:** 1.00**Cust Item ID:****Required Date:** 10/08/09

**Req'd Qty: 1.00**

**Customer ID:****Customer Name:**

**Approvals:**                      **Process Plan:**

Date:

### Tooling:

Date:

**QC:**

Date:

**SPC (Y/N):**

Date:

## Hours

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #: \_\_\_\_\_ Fault Category: Shock tubes NCR: Yes ☒ No ☐ DQA: / Date: 09-10-20

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>52416</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.10.09	170	Aft bend height is 3.25"	CP 09.10.09 per QSI/042	Acceptable	CP 09.10.09 per QSI/042	S 09/10/09	CP 09.10.09 per QSI/042	S 09/10/09

NOTE: Date & initial all entries

September 23, 2009 1:57:40 PM

**Reference:**

**Item Name:** Replacement Skidtube

**Start Qty:** 1.00

**Cust Item ID:****Req'd Qty: 1.00****Customer ID:**

**Customer Name:**

**Process Plan:**

**Date:**

**Tooling:**

Date:

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

## Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	Skidtubes	0.00	0.00							
	Memo	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R [Signature] Aluminum Rod # M109213 BE 09/09/07 3-Grind cross bolt welds flush as per Dwg D3274. 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.									
200	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00	=>	S 02/10/09		(XO)	/		
	Memo										
210	QC	QC10- Inspect visual per QSI004- ground welds	0.00	0.00	=>	S 02/10/09		(XO)	/		
	Memo										
220	HandFinish	Pressure Wash per QSI005 4.3	0.00	0.00	=	M 09/10/13		(XO)	/		
	Memo										

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

September 23, 2009 1:57:46 PM

**Reference:**

Revision ID: M

**Item Name:** Replacement Skidtube

**Start Date:** 9/23/09

**Start Qty:** 1.00

**Cust Item ID:****Required Date:** 10/08/09**Req'd Qty: 1.00****Customer ID:**

**Customer Name:**

**Approvals:**      **Process Plan:**

Date:

**Tooling:**

Date:

**QC:**

Date:

**SPC (Y/N):**

Date:

Sequence ID	Work Center ID	Operation Description	Hours		Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			Set Up	Run							
230	Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  M112260 Memo START TIME: 9:00AM OVEN TEMPERATURE: 320°- FINISH TIME: 9:30AM	0.00	0.00				(X) 1	0		
240	QC Quality Control	QC3- Inspect Part Finish  Memo	0.00	0.00				X1			
250	HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R [ ] N/A [ ] LPS-3 [ ] 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R [ ] [ ] Sikaflex-291 [ ] Sikaflex expire date: [ ] M112391 10/20	0.00	0.00				X1			
260	QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Inspect Nut Plate & Inserts	0.00	0.00				(X) 1	4		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

September 23, 2009 1:57:46 PM

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**Item Name:** Replacement Skidtube

**Start Date:** 9/23/09      **Start Qty:** 1.00

**Cust Item ID:**

**Required Date:** 10/08/09      **Req'd Qty:** 1.00

**Customer ID:****Customer Name:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

## Hours

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 52416

September 23, 2009 1:57:51 PM

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Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:


Date:

SPC (Y/N):

Date:

## Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							
Quality Control		Memo									

09/10/15 

u 9-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 23, 2009 1:57:06 PM

Page 1

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2600-1-190RevD1

Manufactured

No

110

Each

74.0000

1.0000



Extrusion Round 3" 206

89-9-29

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

74

47575

74

110

Each

34.0000

12.0000

D3285-1RevA

Manufactured

No



Cap

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

34

47635

34

150

Each

10.0000

1.0000

D3282-041RevC

Manufactured

No



Float Web (206L/407)

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

LG

10

48389

10

9-9-30

1

1 PD 09.09.30

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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September 23, 2009 1:57:06 PM

Page 2

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	711.0000	12-0 1.0000			



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 83

51529 83

Main Warehouse

ST 628

36013 5

47112 383

48271 240

D3275-1RevA1

Manufactured

No

190

Each

100.0000

12.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 100

47464 1

48117 43

48270 56

12 BE 09/09/06

12 BE 09/09/06

September 23, 2009 1:57:07 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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September 23, 2009 1:57:07 PM

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-03		Purchased	No			250	Each	314.0000	2.0000			
												
Cherry Rivet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

314

111359

96

112314

200

15984

18

D3415-041RevB

Manufactured

No

250

Each

95.0000

1.0000



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

95

33842

95

CCR264SS3-3

Purchased

No

250

Each

271.0000

2.0000



Cherry Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

271

111548

56

111827

115

112314

100

X2 mo 09/10/15

X1 mo 09/10/15

X2 mo 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,439.000	78.0000			



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	112772	
ST	5439	
110511	5439	

x78 m009/10/15

D3536-15RevA Manufactured No



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
47711	5	
48159	12	
51600	26	

x1 m009/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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September 23, 2009 1:57:08 PM

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			270	Each	32.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51609

12

Main Warehouse

ST

20

30754

1

47713

19

D3536-35RevA

Manufactured

No

270

Each

41.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41

48160

15

51628

26

X1 mp 09/10/15

X1 mp 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Comments:

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Required Date: 10/08/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-39RevA		Manufactured	No			270	Each	30.0000	1.0000			



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51637	12	
Main Warehouse		
ST	18	
44648	1	
47714	6	
48161	11	

X1 MD 09/10/15

D3535-15RevB	Manufactured	No				270	Each	15.0000	1.0000			
--------------	--------------	----	--	--	--	-----	------	---------	--------	--	--	--



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	15	
30750	4	
42233	1	
48155	10	

X1 MD 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 23, 2009 1:57:09 PM

Work Order ID: 52416



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-35RevB		Manufactured	No			270	Each	12.0000	1.0000			
Wearshoe												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

12

48157

12

D3535-39RevB

Manufactured

No

270

Each

15.0000

1.0000



Wearshoe

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

15

47525

2

48158

13

D3535-23RevB

Manufactured

No

270

Each

13.0000

1.0000



Wearshoe

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

13

48156

13

XI mo 09/10/15

XI mo 09/10/15

XI mo 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

September 23, 2009 1:57:09 PM

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-3RevC		Manufactured	No			270	Each	72.0000	1.0000			
												
Wearpad												

Warehouse                      Loc Qty                      Loc Code  
Location


Main Warehouse

ST    72

30758    8

33881    17

35697    47

D3537-1RevC		Manufactured	No			270	Each	192.0000	9.0000			
												
Wearpad												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

FP    30

48288    2

50321    28

Main Warehouse

FP17    162

51678    162

51918

X1 JMD 09/10/15

x9 MD 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 23, 2009 1:57:17 PM

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			270	Each	6,864.000	80.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

6764

112116

1764

112612

5000

AN960C416

Purchased

No

270

Each

706.0000

1.0000



washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

706

100993

706

X80 mp 09/10/15

X1 mp 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 23, 2009 1:57:17 PM

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			270	Each	1,186.000	2.0000			
												
Phenolic Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 686

39275 19

42329 121

47628 546

Main Warehouse

ST117 500

51674 500

AN3C4A

Purchased

No

270

Each

1,976.000 80.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1976

112082 14

112314 140

112612 146

112720 1176

112724 500

X 12 mo 09/10/15

X 80 mo 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 23, 2009 1:57:23 PM

Work Order ID: 52416

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4C5A		Purchased	No			270	Each	603.0000	1.0000			



BOLT

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	603	
104936	19	
<u>110552</u>	82	
112243	500	
18918	2	

X2 mo 09/10/15

D2646RevC



Aft Cap

Manufactured No

270 Each 56.0000 1.0000



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	56	
20208	0	
43801	1	
<u>46327</u>	6	
48109	49	

X1 mo 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

September 23, 2009 1:57:23 PM

Work Order ID: 52416



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3413-I RevA		Manufactured	No			270	Each	22.0000	1.0000			

Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
48123	22	

XI MO 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <b>CP</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3274</b>	REV. D SHEET 1 OF 4
DATE <b>06.12.19</b>		TITLE <b>SKIDTUBE ASSEMBLY</b> SCALE <b>NTS</b>	
<b>A</b>	<b>04.03.15</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>04.08.09</b>	<b>MOVE SADDLE HOLE: 42.14 WAS 42.76</b>	
<b>C</b>	<b>05.03.16</b>	<b>ADD -043; NEW INSERTS</b>	
<b>D</b>	<b>06.12.19</b>	<b>NEW INSERTS, SS WEARSHOE + GASKET</b>	

RELEASED  
07.02.12  
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

w/o  
52466

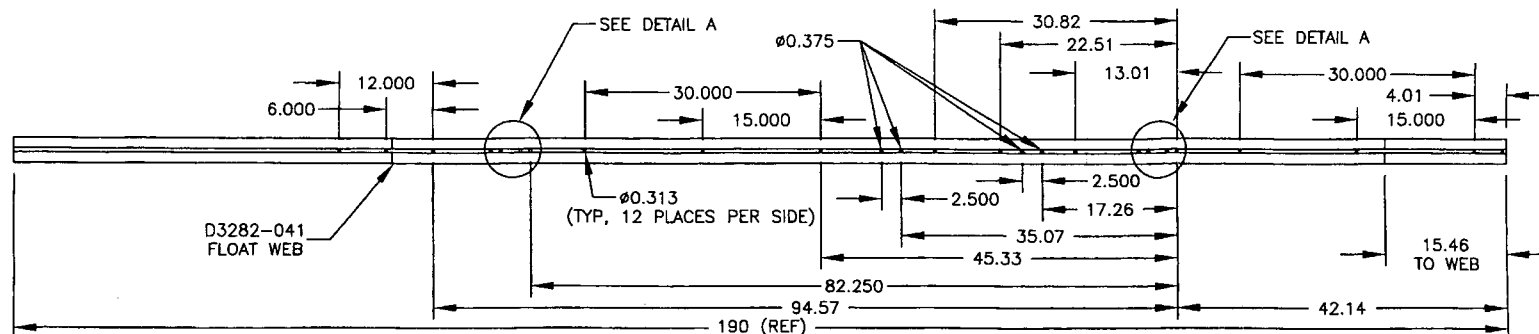
#### GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

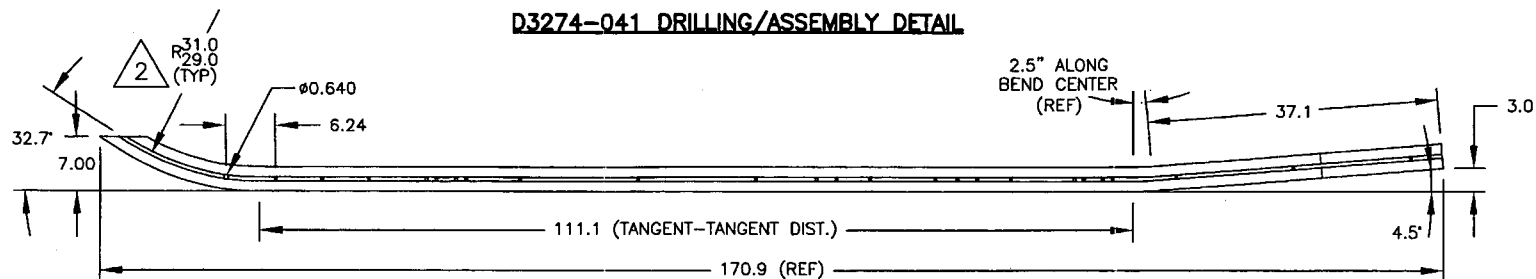
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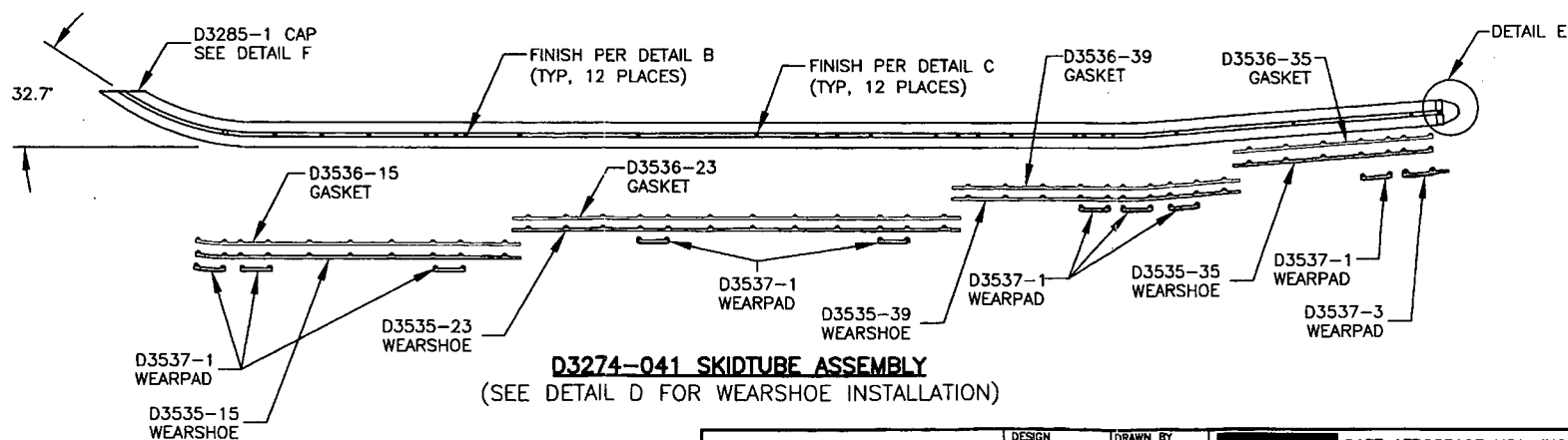
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

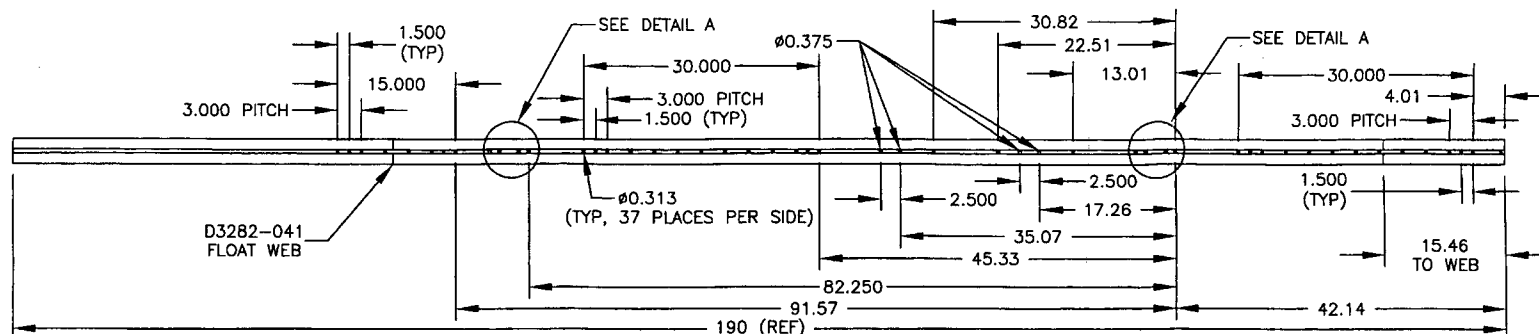
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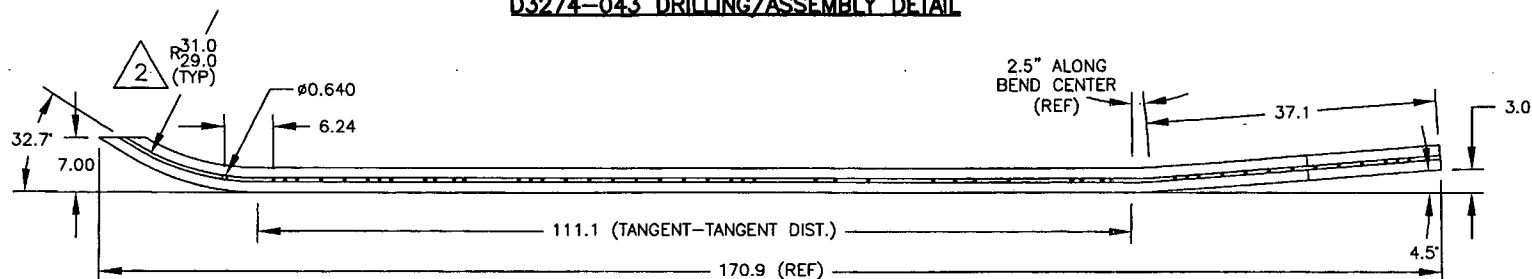
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, MA
DATE	06.12.19	DRAWING NO.	D3274	REV. D
		TITLE	SKIDTUBE ASSEMBLY	SHEET 2 OF 4
				SCALE 1:15

5246

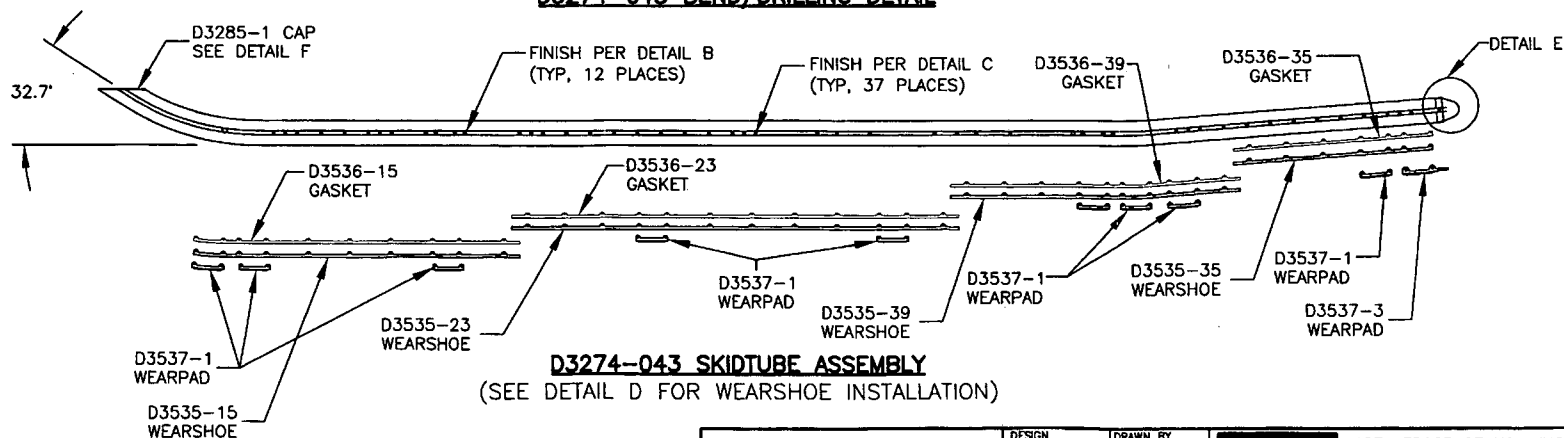
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

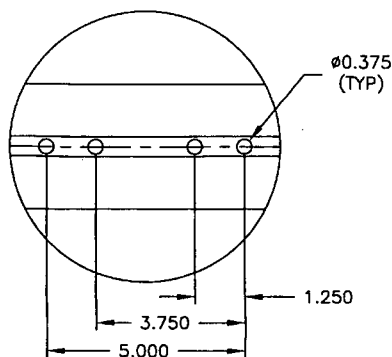
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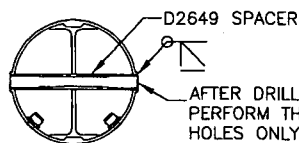
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CHECKED	H	APPROVED	H	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15

5246

# **DETAIL A: DRILL DETAIL**

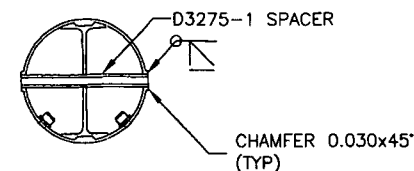


# **DETAIL B** FOR 0.375 HOLES ONLY

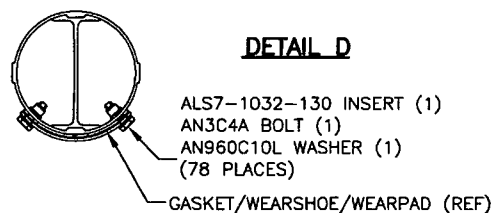


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

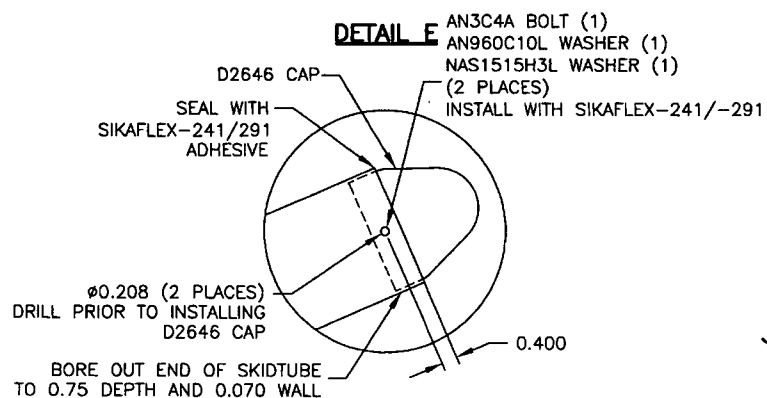
# **DETAIL C** FOR 0.313 HOLES ONLY



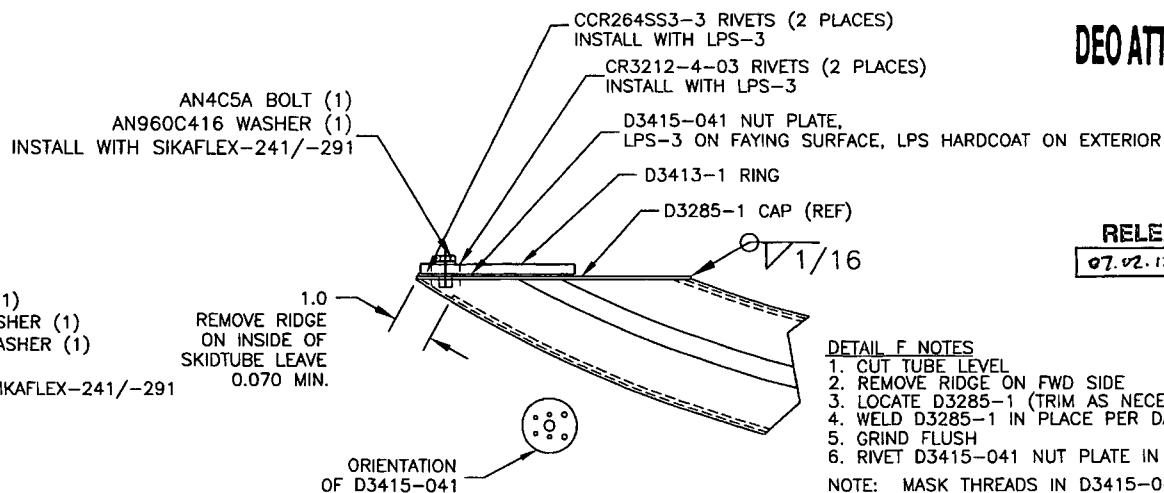
# **DETAIL D**



# **DETAIL E**



# **DETAIL F: END FINISHING DETAIL**



**DEO ATTACHED**

**RELEASED**

07.02.12

- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

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CHECKED	APPROVED	CP	PH	DRAWING NO.	REV. D
				D3274	SHEET 4 OF 4
DATE	06.12.19		TITLE		SCALE
				SKIDTUBE ASSEMBLY	1:3

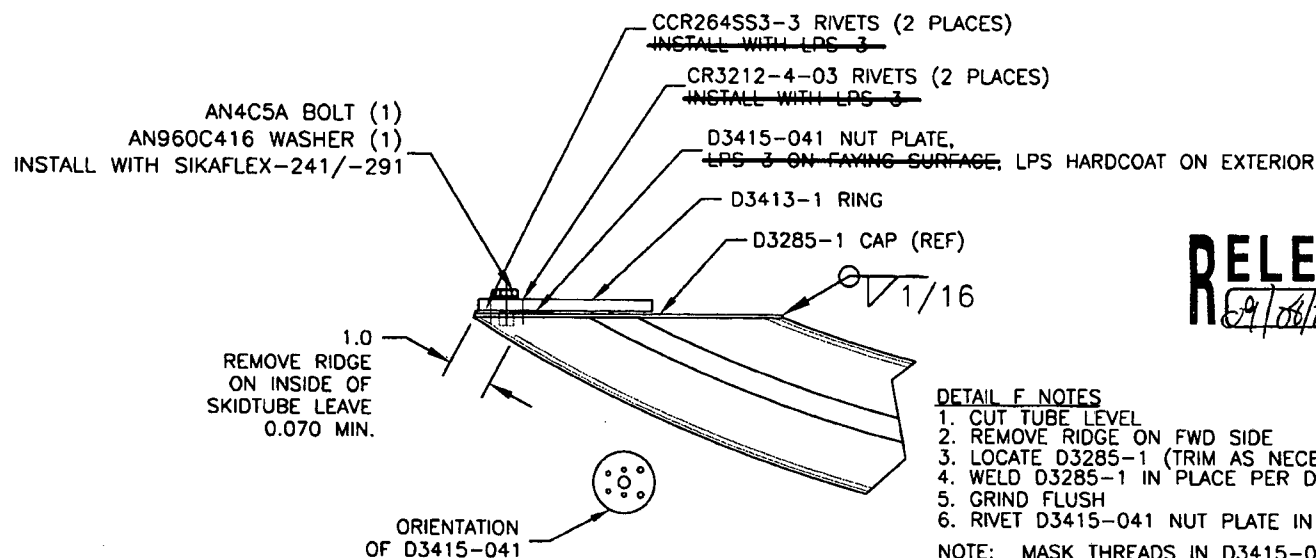
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	<b>DART AEROSPACE USA, INC</b>	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>1</i>	MFG. APPR. <i>M</i>	APPROVED <i>MAP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

NO. 201

**AWS D17.1.2001  
QUALIFICATION TEST RECORD**

Name: Barclay Elliott  
Job number: 47927A  
Part number: D206 642 541  
Description: float tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Pat. Dair Date of Test Coupon 09-06-04  
Welder Barclay Elliott Date of Test Coupon 09-06-04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld